

NCR-19-7487



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D4131-043
Job Sheet 200070



Part No: D4131-043

Job Qty: 10 pcs

Part Name: Doubler Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/6/19

Job Tracking No:

Due Date: 9/23/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 2,9 IPP Rev:A 10.10.06 new issue DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		9/23/19	0.17	1.12	Waterjet - Flow	9/16/19	JRB
120	QC 8	10 pcs		9/23/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Small Fab - 2 - B4B	10 pcs		9/23/19	0.00	0.64	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		

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Container No: S213837



Part: D4131 - 043

Job No: 200070

Serial No/Batch: S213837

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/16/19

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150	QC 5	10 pcs	9/23/19	0.00 0.00	Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
160	Handfinish - 1-1 Chemical-B4B	10 pcs	9/23/19	0.00 0.57	QC 5 - 40	SEP 25 2019
					QC 5 - 61	
					QC 5 - 81	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	SEP 25 2019
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
161	QC 7	10 pcs	9/23/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	

				QC 7 - 15		
				QC 7 - 17		
				QC 7 - 18		
				QC 7 - 19		
				QC 7 - 2		
				QC 7 - 28		
				QC 7 - 3		
				QC 7 - 30		
				QC 7 - 34		
				QC 7 - 36		
				QC 7 - 37		
				QC 7 - 41		
				QC 7 - 47		
				QC 7 - 48		
				QC 7 - 51		
				QC 7 - 58	DAS 58 0-80	
				QC 7 - 59	SEP 25 2019	
				QC 7 - 60		
				QC 7 - 9		
				QC 7 - 68		
				QC 7 - 50		
				QC 7 - 67		
				QC 7 - 40		
				QC 7 - 24		
				QC 7 - 43		
				QC 7 - 61		
				QC 7 - 81		
165	Small Fab - 2 - B4B	10 pcs	9/23/19	0.00 0.64	Small Fab - 1 - B4B	DAS 58 0-80
					Small Fab - 2 - B4B	SEP 25 2019
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
166	QC 5	10 pcs	9/23/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
180	Packaging 3-1 - Stock - B4B	10 pcs	9/23/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	ST 079
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
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				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	29	10 pcs	9/23/19	0.00 0.00	QC 21 - SA - 21 ✓
					QC 21 - SA - 70
					QC 21 - SA - 53

THU 9-26-2019

Oscar

Part Op 100 - 1-Cut D4131-7 as per Dwg Dwg Rev: C Prog Rev: C 2-Deburr as required

Descriptions: 120 - QC8- Inspect parts - second check

130 - Small Fab - COUNTER SINK AS PER DWG Deburr if necessary.

150 - QC5- Inspect part completeness to step on W/O

160 - Chemical Conversion Coat per QSI005 4.1

161 - QC7-Inspect Chemical Conversion Coat

165 - Small Fab - ASSEMBLE NUT PLATES AS PER DWG

166 - QC5- Inspect part completeness to step on W/O

180 - Identify as per dwg & Stock Location: _____

190 - QC21- Final Inspection - Work Order Release

STO 79

DAS

21

9-25

SEP 26 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	1.8070 sf (.1807 ea)	100-Waterjet - Flow - 1	5190194
MS20426AD3-3	Rivet	80 Ea (8 ea) 232	165-Small Fab - 2 - B4B	5174201
MS21069L3	Anchor Nut	40 Ea (4 ea) 116	165-Small Fab - 2 - B4B	5158310 5193885

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.063	2	447	0
165-Small Fab - 2 - B4B	MS20426AD3-3	80	5,845	0
	MS21069L3	40	161	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler Assembly	0.098Inches + 0.004 - 0.001	0.102 0.097	0.100	Diameter
2	Doubler Assembly	0.191Inches + 0.005 - 0.001	0.196 0.190	0.193	Diameter
3	Doubler Assembly	0.250Inches ± 0.010	0.260 0.240		
4	Doubler Assembly	0.500Inches ± 0.010	0.510 0.490		
5	Doubler Assembly	0.405Inches ± 0.010	0.415 0.395		
6	Doubler Assembly	0.405Inches ± 0.010	0.415 0.395		
7	Doubler Assembly	0.590Inches ± 0.030	0.620 0.560		
8	Doubler Assembly	0.660Inches ± 0.030	0.690 0.630		
9	Doubler Assembly	3.640Inches ± 0.030	3.670 3.610		
10	Doubler Assembly	4.000Inches ± 0.010	4.010 3.990		
11	Doubler Assembly	4.100Inches ± 0.030	4.130 4.070		
12	Doubler Assembly	4.810Inches ± 0.030	4.840 4.780		
13	Doubler Assembly	4.600Inches ± 0.010	4.610 4.590		
14	Doubler Assembly	5.410Inches ± 0.030	5.440 5.380		
15	Doubler Assembly	0.063Inches ± 0.010	0.073 0.053		

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Entered: YR Date: Oct 23/19



NCR No. 19-7487 **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

Job: <u>200070</u> Part No. <u>D4131-043</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☒ Supplier ☐ Quality ☐			
Date : <u>SEP 16 2019</u>	Sequence #: <u>120</u>	QTY Affected : <u>3 of 32</u>		MRB (QSI042) Completed By <u>DAS 40</u> <u>SEP 16 2019</u>	
Description Work Order Deviation <u>-outside diameter out of tolerance</u> <u>-5.41 +/- 0.030</u> <u>-5.354</u>		Disposition <u>-Scrap</u>		Lead hand / Supervisor <u>DAS 30</u> <u>9-89</u> <u>SEP 16 2019</u>	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☒ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☒ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐		QC / QA Coordinator <u>68</u> <u>9-89</u> <u>SEP 16 2019</u>			
Other/Details:					